

Date: Tuesday, 16/01/2007 9:56:56 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 30286	
Estimate Number : 12644	
P.O. Number : N/A	Part Number : G106072
This Issue : 16/01/2007 S.O. No. : N/A	Drawing Number : G10607 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <u>CL</u>	Due Date : 26/01/2007
Checked & Approved By : _____	Qty: 10 Um: Each
Comment : Est Rev:A New Issue 07-01-16 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S050	2024-T3 .050 sheet
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Comment: Qty.: 0.1892 sf(s)/Unit Total: 1.8921 sf(s)

2024-T3 .050 sheet

*****Grain must Run Along 8.59" Dim *****

Batch: M103210

M 07 01 16

(10)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg G10607

Dwg Rev: A

Prog Rev: A

M 07 01 16

(10)

2-Deburr if necessary

*****Use same cutting file for -1 & -2 *****

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M 07 01 16

(10)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

M 07/01/17 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/10/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 16/01/2007 9:56:56 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 30286

Part Number: G106072

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-C'SINK AS PER DWG G10607,

****NOTE:-1 & -2 ARE C'SINKED ON OPPOSITE SIDES****

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 07.01.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries


W. 30574
~~333~~



UNLESS OTHERWISE NOTED.

1. MAT'L: ALUM 0.050 THICK, 2024-T3.
2. ALL "A" AND "B" HOLES ARE #40 DRILL ($\phi 0.098$), TO BE DRILLED TO SIZE AT ASSEMBLY.
3. COUNTERSINK 100° (NEAR SIDE) "B" HOLES FOR RIVETS MS20426AD-4 ($\phi 0.221$)
4. FINISH: ETCH, ALODINE PER MIL C5541-1A,

-2 SAME AS -1 EXCEPT "B" HOLES
C'SK NEAR SIDE

BREAK ALL EDGES ✓ UNLESS OTHERWISE SPECIFIED DIMENSION ARE IN INCHES DIMENSIONAL TOLERANCES 3 DECIMALS ± .010 2 DECIMALS ± .020 1 DECIMAL ± .050 ANGULAR ± 1'	DRAWN	T.S.	DATE	 GENEVA AVIATION 10108 - 32nd Ave W Everett, WA 98204 (425)353-7400 FAX(425)347-7100		
	CHECK		DATE			
	DESIGN		DATE			
	APPROVAL	RGC	DATE		4-3-95	
THIS DRAWING INCLUDES INFORMATION PROPRIETARY TO GENEVA AVIATION AND SHALL NOT BE USED OR DUPLICATED BY ANYONE WITHOUT THE WRITTEN PERMISSION OF GENEVA AVIATION INC.				TITLE DOUBLER DETAIL		
			DWG NO.	G10607	REV.	A
			PRO NO.	GA159	SIZE	B
					SCALE	1/1
					SHT.	1 OF

DART AEROSPACE LTD		Work Order: 30286
Description: Doubler		Part Number: G10607-2
Inspection Dwg: G10607 , Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.60	+/- 0.030	4.603	✓		VERN	
5.20	+/- 0.030	5.208	✓		VERN	
Ø 0.191	+0.005-0.001	0.191	✓		VERN	
Ø 0.098	+0.004-0.001	0.098	✓		VERN	
0.343	+/- 0.010	0.344	✓		VERN	
0.400	+/- 0.010	0.400	✓		VERN	
1.300	+/- 0.010	1.300	✓		VERN	
1.250	+/- 0.010	1.248	✓		VERN	
1.700	+/- 0.010	1.703	✓		VERN	
0.350	+/- 0.010	0.347	✓		VERN	
4.078	+/- 0.010	4.080	✓		VERN	
3.950	+/- 0.010	3.947	✓		VERN	
0.450	+/- 0.010	0.453	✓		VERN	

Measured by: MM/JLM	Audited by: DA	Prototype Approval: N/A
Date: 07/01/16	Date: 07/01/17	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

SHIP TO:
 TRENTWOOD WORKS
 10000 10TH AVE
 SPOKANE, ID 83401

SOLD TO:
 TRENTWOOD WORKS
 10000 10TH AVE
 SPOKANE, ID 83401

**KAISER
ALUMINUM**

Trentwood Works - Spokane, WA 99215
 Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
 4062914

CUSTOMER PO NUMBER: N18187		WORK PACKAGE:		CUSTOMER PART NUMBER:		SHIP UNLOAD ID: 10082070		GOVT CONTRACT NUMBER:	
KAYSER ORDER NO: 1033832	LINE ITEM: 1	SHIP DATE: 24-MAR-2008	ALLOY: 2024	CLAS:	CLAD	TEMPER: T3	QUANTITY: 223 PCS EST.	WEIGHT: 48.000 IN	LENGTH: 144.000 IN
WEIGHT SHIPPED: 7885 LB		W/L NUMBER: 207855	GUAGE: 0.0600 IN						

Certified Specifications

AM9 4041/RevP
BATS 2505/RevNC

AMS-QQ-A-280/5/RevA
DM8 2174/RevB

ASTM B 209/Rev04

Test Code: 4013

Test Results

Lot: 350042A8 Case 218

Drop 16

Insert 2

Tensile: Temper
T3

Dir / # Tests
LT / 2 (Min:Max)

Ultimate KSI (MPa)
63.9 : 64.7 ✓
(441 : 446)

Yield NEI (MPa)
44.8 : 45.8 ✓
(309 : 316)

Elongation %
15.3 : 1:3.8 ✓

MRS Deflection : 0.017 IN

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZA	TOT	OTHER
Actual	0.09	0.24	4.57	0.58	1.40	0.01	0.13	0.02	0.01	0.01		0.04

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
2024 MIN	0.00	0.00	3.80	0.30	1.20	0.00	0.00	0.00	0.00	0.00	EACH	0.05
MAX	0.50	0.50	4.90	0.90	1.80	0.10	0.25	0.15	0.05	0.05	TOT	0.15
LINER MIN	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	EACH	0.03
MAX	0.25	0.40	0.05	0.05	0.05	0.00	0.05	0.03	0.05	0.00	TOT	0.00
Aluminum Remains												

TEST NOTES

TEST NOTES
MATERIAL MEETS MINIMUM RESIDUAL STRESS (MRS)/CHEMICAL
MILLING QUALITY (CMQ) REQUIREMENTS.

